

008997



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C45

Job Sheet 191756



Part No: C45

Job Qty: 1 pcs

Part Name: C-Series Remote Hook 4,500 lbs Lift Capacity



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/7/19

Job Tracking No:

Due Date: 4/30/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: C45 REV.2 IPP REV:A 18.01.29 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	External Load - 1	1 pcs	4/30/19		0.00	3.33	External Load - 1		AP
							External Load - 2		
							External Load - 3		
110	External Load - 2 - B4B	1 pcs	4/30/19		0.00	3.33	External Load - 1 - B4B		AP 2019/05/13 Michel
							External Load - 2 - B4B		
							External Load - 3 - B4B		
120	QC 5	1 pcs	4/30/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
130	Packaging 3-2 - Stock - B4B	1 pcs	4/30/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Container No: S167649



Part: C45

Job No: 191756

Serial No/Batch: S167649

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 03/28/19

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DAS 30 9-09

MAY 3 2019

Plex 3/7/19 2:49 PM Dart.lajeunesse.marie

					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	4/30/19	0.00 0.00		QC 21 - SA - 21	DAG
					QC 21 - SA - 70	21 MAY 13 2019
					QC 21 - SA - 53	0-02

Part Op 100 - 1- PICK C45-2-1 AND LASER ENGRAVE AS PER DWG . SEE NOTE 3 AND 4 ON SHEET 3. 2- ASSEMBLE AS
 Descriptions: PER DWG 3- PERFORM ALL NECESSARY TEST USING FAI TEST SHEET.

110 - 1- PICK C45-2-1 AND LASER ENGRAVE AS PER DWG . SEE NOTE 3 AND 4 ON SHEET 3. 2- ASSEMBLE AS
 PER DWG 3- PERFORM ALL NECESSARY TEST USING FAI TEST SHEET.

120 - (QC5- Inspect part completeness to step on W/O)

130 - Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1/4-20-3/8	Set Screw	2 Ea (2 ea)	100-External Load - 1	5048557-1
188-FSCS-1032-5/8	Set Screw	4 Ea (4 ea)	110-External Load - 2 - B4B	5047611
2595K2 7856K	Heat Shrink	500 1 ft (1 ea)	110-External Load - 2 - B4B	5049360S 134207
32448	16-14 AWG Knife Connector	4 2 Ea (2 ea)	110-External Load - 2 - B4B	5151100
600-1309-A	Label	1 pcs (1 ea)	110-External Load - 2 - B4B	
600-1312	Caution Sticker	1 pcs (1 ea)	110-External Load - 2 - B4B	
AN4-23A	Bolt	2 Ea (2 ea)	110-External Load - 2 - B4B	F123434-1
AN5-21A	Bolt	4 Ea (4 ea)	110-External Load - 2 - B4B	5097081-1
C10-41	Strain Relief Connector	1 Ea (1 ea)	110-External Load - 2 - B4B	5083917
C2-14-2	Label Rivets	2 Ea (2 ea)	110-External Load - 2 - B4B	
C45-1-1	Manual Knob Release	1 pcs (1 ea)	110-External Load - 2 - B4B	5029295
C45-10-1	Lock Spring Pin	1 Ea (1 ea)	110-External Load - 2 - B4B	5029293
C45-10-2	Lock Spring	1 pcs (1 ea)	110-External Load - 2 - B4B	5135379
C45-11-1	Sideplate, Solenoid Side	1 pcs (1 ea)	110-External Load - 2 - B4B	5029296
C45-11-2	Locating Pin	2 Ea (2 ea)	110-External Load - 2 - B4B	5089115
C45-12-1	Lock Bushing	2 pcs (2 ea)	110-External Load - 2 - B4B	5152223
C45-12-2	Lock Shaft	1 pcs (1 ea)	110-External Load - 2 - B4B	5046506
C45-12-3	Lock	1 pcs (1 ea)	110-External Load - 2 - B4B	5083337
C45-12-4	Lock Roller	1 pcs (1 ea)	110-External Load - 2 - B4B	5108073

P	C45-12-5	Lock Roller Pin	1 pcs (1 ea)	110-External Load - 2 - B4B	5093171
	C45-12-6P	Retaining Ring	2 Ea (2 ea)	110-External Load - 2 - B4B*	5029303
	C45-13-1	Keeper Bushing	2 pcs (2 ea)	110-External Load - 2 - B4B	5125630
	C45-13-2	Teflon Keeper, Spacer	2 Ea (2 ea)	110-External Load - 2 - B4B	5040660
N	C45-13-3	Keeper Shaft	1 Ea (1 ea)	110-External Load - 2 - B4B	5157825
P	C45-13-4	Keeper	1 pcs (1 ea)	110-External Load - 2 - B4B	5170614
N	C45-13-5	Keeper Spring	1 pcs (1 ea)	110-External Load - 2 - B4B	5029308
	C45-2-1	Sideplate - MRK	1 pcs (1 ea)	110-External Load - 2 - B4B	5148693
	C45-3-1	Radial Bearing	2 Ea (2 ea)	110-External Load - 2 - B4B	5097909
	C45-3-10	Latch Shaft	1 pcs (1 ea)	110-External Load - 2 - B4B	5041144
	C45-3-11	Actuator	1 pcs (1 ea)	110-External Load - 2 - B4B	5042953
	C45-3-12	Latch Roller Bearing	1 Ea (1 ea)	110-External Load - 2 - B4B	5097903
	C45-3-2	Latch Roller Pin	1 pcs (1 ea)	110-External Load - 2 - B4B	5029316
	C45-3-2-1	Snap Ring	2 Ea (2 ea)	110-External Load - 2 - B4B	5097898
	C45-3-3	Latch Roller	1 pcs (1 ea)	110-External Load - 2 - B4B	5127763
	C45-3-4	Pin	2 pcs (2 ea)	110-External Load - 2 - B4B	5133668
	C45-3-4-1	Retaining Ring	4 Ea (4 ea)	110-External Load - 2 - B4B	5114803
P	C45-3-5P	Teflon Spacer	2 Ea (2 ea)	110-External Load - 2 - B4B*	5029321
P	C45-3-6	Latch	1 pcs (1 ea)	110-External Load - 2 - B4B	5123057
	C45-3-7	Link	1 pcs (1 ea)	110-External Load - 2 - B4B	5029322
	C45-3-8A	Actuator Shaft Bushing	1 pcs (1 ea)	110-External Load - 2 - B4B	5078570
	C45-3-8B	Actuator Shaft Bushing	1 pcs (1 ea)	110-External Load - 2 - B4B	5163197
	C45-3-9	Lever Spring	1 pcs (1 ea)	110-External Load - 2 - B4B	5089520
	C45-4-1 -P0	Trunnion Bushing	2 pcs (2 ea)	110-External Load - 2 - B4B*	5122724
	C45-4-4A	C45 Load Beam Assembly	1 pcs (1 ea)	110-External Load - 2 - B4B	5151334
	C45-4-5	Loadbeam Spacer	1 pcs (1 ea)	110-External Load - 2 - B4B	5043615
	C45-5-1	Lever Stop Pin	1 Ea (1 ea)	110-External Load - 2 - B4B	5040657
	C45-5-2	Lever Stop	1 pcs (1 ea)	110-External Load - 2 - B4B	5029330
	C45-7-1	LOADBEAM BUMPER	1 pcs (1 ea)	110-External Load - 2 - B4B	5156421
N	C45-7-2	Lock Bumper	2 pcs (2 ea)	110-External Load - 2 - B4B	5163721
N	C45-8-1-2	Solenoid Nut	2 pcs (2 ea)	110-External Load - 2 - B4B	5163995
	C45-8-2	Solenoid	1 pcs (1 ea)	110-External Load - 2 - B4B	5157835
	C45-8-4	Solenoid Cover Gasket	1 pcs (1 ea)	110-External Load - 2 - B4B	5122623
N	C45-8-5	Solenoid Cover	1 pcs (1 ea)	110-External Load - 2 - B4B*	5046392
P	C45-9-1	Clock Spring Cover	1 pcs (1 ea)	110-External Load - 2 - B4B	5029337
	C45-9-2	Clock Spring	1 pcs (1 ea)	110-External Load - 2 - B4B	5107946
	EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	110-External Load - 2 - B4B	5161539
01004-08-047	EL314-SJTOW	Long Line Electrical Wire, 14/3 Gauge	1 ft (1 ea)	110-External Load - 2 - B4B	5159114
	MS21044N5	Nut	4 Ea (4 ea)	110-External Load - 2 - B4B	5097089
	MS27039-4-08	Screw	1 Ea (1 ea)	110-External Load - 2 - B4B	5039330-1
	NAS1149F0403P	Washer	3 Ea (3 ea)	110-External Load - 2 - B4B	5097088-2
	NAS1149F0563P	Washer	8 Ea (8 ea)	110-External Load - 2 - B4B	5067901

Loctite 242 (M138933)

Loctite 620 (5166705)

Aeroshell grease NO. 7 (5138964)

Saf-T-eye (M128063)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-External Load - 1	188-FPSS-1/4-20-3/8	2	122	0
110-External Load - 2 - B4B	188-FSCS-1032-5/8	4	106	0
	2595K2	1	19	0
	32448	2	219	0
	600.1309-A	1	97	0
	600.1312	1	19	0
	AN4-23A	2	690	0
	AN5-21A	4	364	0
	C10-41	1	28	0
	C2-14-2	2	188	0
	C45-1-1	1	7	0
	C45-10-1	1	162	0
	C45-10-2	1	11	0
	C45-11-1	1	0	0
	C45-11-2	2	43	0
	C45-12-1	2	15	0
	C45-12-2	1	5	0
	C45-12-3	1	11	0
	C45-12-4	1	19	0
	C45-12-5	1	47	0
	C45-12-6	2	114	0
	C45-13-1 PO	2	0	0
	C45-13-2	2	70	0
	C45-13-3	1	8	0
	C45-13-4	1	0	0
	C45-13-5 P	1	0	0
	C45-2-1	1	3	0
	C45-3-1	2	121	0
	C45-3-10	1	9	0
	C45-3-11	1	5	0
	C45-3-12	1	86	0
	C45-3-2 P	1	0	0
	C45-3-2-1	2	93	0
	C45-3-3	1	25	0
	C45-3-4	2	60	0
	C45-3-4-1	4	165	0
	C45-3-5	2	99	0
	C45-3-6	1	4	0
	C45-3-7 P	1	0	0
	C45-3-8A	1	30	0
	C45-3-8B	1	5	0
	C45-3-9	1	31	0
	C45-4-1	2	16	0
	C45-4-4A	1	4	0
	C45-4-5	1	4	0
	C45-5-1	1	46	0
	C45-5-2 P	1	0	0
	C45-7-1	1	18	0
	C45-7-2	2	4	0
	C45-8-1-2	2	0	0
	C45-8-2	1	6	0
	C45-8-4	1	9	0
	C45-8-5	1	19	0
	C45-9-1 P	1	0	0
	C45-9-2	1	45	0
	EL-PLUG-M	1	31	0
	EL314-SJTOW	1	718	0
	MS21044N5	4	89	0
	MS27039-4-08	1	229	0
	NAS1149F0463P	3	563	0
	NAS1149F0563P	8	433	0

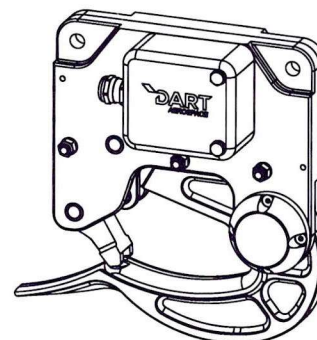
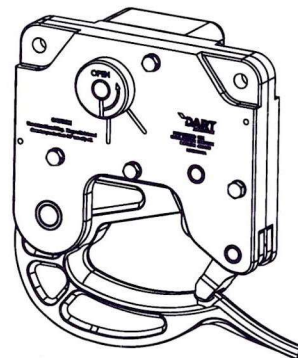
Part Specifications

Specifications could not be found.

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ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			C45-1-1	1	MANUAL KNOB RELEASE	6061		2
			C45-2-1	1	SIDE PLATE	7075-T6		2
		B/O	C45-3-1	2	RADIAL BEARING		(KAMAN #1606 2RS)	3
			C45-3-2	1	LATCH ROLLER PIN	O-1		3
		B/O	C45-3-2-1	2	SNAP RING	STEEL	Ø3/8 (KAMAN 1400-0037)	3
			C45-3-3	1	LATCH ROLLER	4140/4142		3
			C45-3-4	2	LINK PIN	O-1		3
		B/O	C45-3-4-1	4	RETAINING RING	BERYLLIUM COPPER	3/16 SHAFT (MCMASTER-CARR #98410A110)	3
		B/O	C45-3-5	2	SPACER	TEFLON	(MCMASTER-CARR #95606A180)	3
			C45-3-6	1	LATCH	17-4 S.S.		3
			C45-3-7	1	LINK	O-1		3
			C45-3-8A	1	ACTUATOR SHAFT BUSHING	AL BRONZE 630		3
			C45-3-8B	1	ACTUATOR SHAFT BUSHING SOLENOID SIDE	AL BRONZE 630		3
		B/O	C45-3-9	1	LEVER SPRING	303 S.S.		3
			C45-3-10	1	LATCH SHAFT	17-4 S.S.		3
			C45-3-11	1	ACTUATOR	17-4 S.S.		3
		B/O	C45-3-12	1	DU BEARING		(KAMAN 06DU06)	3
			C45-4-1	2	TRUNNION BUSHING	AL-BRONZE 630		2
			C45-4-5	1	LOAD BEAM SPACER	4140/4142 Q&T		2
		B/O	C45-5-1	1	LEVER STOP PIN	STEEL	1/4 X 1-3/8 (MCMASTER-CARR #98381A545)	2
			C45-5-2	1	LEVER STOP	304 S.S.		2
			C45-7-1	1	LOAD BEAM BUMPER	POLYURETHANE		2
			C45-7-2	2	LOCK BUMPER	PLOYURETHANE		2
			C45-8-1-2	2	SOLENOID NUT	304 S.S.		2
			C45-8-2	1	SOLENOID ASSY		(REF: H-2553-020)	2
			C45-8-4	1	SOLENOID COVER GASKET	BLENDED RUBBER		2
			C45-8-5	1	SOLENOID COVER	6061		2
			C45-9-1	1	CLOCK SPRING COVER	6061		2
			C45-4-4A	1	C45 LOAD BEAM ASSY.			2
		B/O	C45-9-2	1	CLOCK SPRING	303 S.S.	.03 X .75 X 15 DENDOFF SPRING	2
		B/O	C45-10-1	1	SPRING PIN	S.S.	1/4 X 1.0 (MCMASTER-CARR #92373A183)	2
			C45-10-2	1	LOCK SPRING C45 HOOK	302 S.S.		3
			C45-11-1	1	SIDE PLATE SOLENOID	7075-T6		2
		B/O	C45-11-2	2	LOCATING PIN	S.S.	Ø3/16 X 1 (MCMASTER-CARR #90145A510)	2
			C45-12-1	2	LOCK BUSHING	4140/4142		3
			C45-12-2	1	LOCK SHAFT	4140/4142		3
			C45-12-3	1	LOCK	4140/4142		3
			C45-12-4	1	LOCK ROLLER	4140/4142		3
			C45-12-5	1	LOCK ROLLER PIN	4140/4142		3
		B/O	C45-12-6	2	RETAINING RING	STEEL	(KAMAN #N1400-0050)	3
			C45-13-1	2	KEEPER BUSHING	4140/4142		3
		B/O	C45-13-2	2	SPACER	NYLON	(MCMASTER-CARR #95606A210)	3
			C45-13-3	1	KEEPER SHAFT	4140/4142		3
			C45-13-4	1	KEEPER	4140/4142		3
		B/O	C45-13-5	1	KEEPER SPRING	303 S.S.	CHAMBERLAIN SPRING	3
			600.1309	1	LABEL 	ALUMINUM		N/S
			600.1309-A	1	LABEL 	ALUMINUM		N/S
		B/O	600.1312	1	CAUTION STICKER 			N/S
		B/O	C2-14-2	2	LABEL RIVETS 	18-8 S.S.	NO 4 (MCMASTER-CARR #91654A106)	N/S
		B/O	188-FPS3-1/4 20-3/8	2	SET SCREW	S.S.	1/4-20 (MCMASTER-CARR #92313A535)	2
		B/O	188-FSCS-1032-5/8	4	SCREW	S.S.	10-32 X 5/8 FSHCS (MCMASTER-CARR #92210A303)	2
		B/O	AN4-23A	2	BOLT	STEEL	1/4-28 X 2.41	2
		B/O	AN5-21A	4	BOLT	STEEL	5/16-24 X 2.22	2
		B/O	MS21044N5	4	LOCK NUT	S.S.	5/16	2
		B/O	AN960-416	3	WASHER	STEEL	1/4	2
		B/O	AN960-516	8	WASHER	STEEL	Ø5/16	2
		B/O	MS27039-4-08	1	BOLT	STEEL	1/4-28 X .531	2
		B/O	EL 314-SJTOW 3/14	1	3 WIRE		(TEXCAN 314-SJTOW 3/14)	2
		B/O	32448	2	16-14 AWG KNIFE CONNECTOR		(ALLIED ELECTRONICS 32448)	2
		B/O	C10-41	1	STRAIN RELIEF CONNECTOR	BRASS	1/2 TRADE SIZE (MCMASTER-CARR #6907K14)	2
		B/O	EL-PLUG-M	1	MALE PLUG	PE High Density	(MCMASTER-CARR #7216K5)	2
		B/O		1	HEAT SHRINK TUBE	RUBBER	(MCMASTER-CARR #2595K22)	N/S

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1	15-0018	UPDATED TO NEW DRAFTING STANDARDS, CHD P/NS TO REFLECT AN & MS NUMBERS. ADDED REBUILD AND CUSTOMER REBUILD NOTES.	1/20/2015	DPD
2	15-0230	C45-5-1 CHD B/O WAS Ø1/4 X 1-1/2 #98381A546 IS Ø1/4 X 1-3/8 #98381A545. C45-1-2 REPLACED W/ 188-FPS3-1/4 20-3/8. C45-9-1-1 REPLACED W/ 188-FSCS-1032-5/8. MS27039-4-10 REPLACED W/ MS27039-4-08. CORD GRIP REPLACED W/ C10-41. 32448 ADDED TO BOM QTY 2. ADDED ENGRAVING NOTES & DETAILS.	9/10/2015	DPD



NOTES:

- FOR REBUILD ONLY.
- FOR CUSTOMER REBUILD ONLY.

DART AEROSPACE	
TITLE C45-HOOK	
DWG NO. C45	REV 2
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES XXX ± .005 XXX ± .01 X ± .1	DRAWN BY: <i>D. Weil</i> APPROVED REXT TREAT FINISH SPEC 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE 1:4	DATE SHEET 1 OF 3

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details: _____			



Remote Cargo Hook Test Form

C45

Work Order 191756

Customer 13882

Serial Number 5167649

Date 2019-4-29

# of Releases	Load (Lbs.)	Release Method	Remarks	Result	Pass/fail
1	11,250	Static Hold	Hold for two Minutes and reduce load to zero	N/A	Pass
10	2,250	Electrical, 25 volts	No "hang ups" permitted	N/A	Pass
2	4,500	Electrical, 22 volts	Current shall not exceed 12.4A	9.5 A	Pass
2	3,500	Electrical, 22 volts	Current shall not exceed 12.4A	9.3 A	Pass
2	2,500	Electrical, 22 volts	Current shall not exceed 12.4A	8.7 A	Pass
2	1,500	Electrical, 22 volts	Current shall not exceed 12.4A	8.2 A	Pass
2	500	Electrical, 22 volts	Current shall not exceed 12.4A	8.1 A	Pass
1	4,500	Electrical, 20 volts	Current shall not exceed 11.3A	7.8 A	Pass
1	4,500	Electrical, 28 volts	Current shall not exceed 15.8A	8.8 A	Pass
1	4,500	Manual		N/A	Pass
1	4,500	Impact Test	Impact shackle 10 times, shall not release	N/A	Pass
1	N/A	Solenoid Ohms	Shall not exceed 1.7-2.0 Ohms	2.0 Ohms	Pass
1	N/A	Electrical Continuity	Across both wires	N/A	Pass

Test Conducted By:

Michel Lelonde

Technician

Submit

Signature:

Sylvie Sanchez
QC 5 Small FAB / QA